

IN THE CLAIMS:

This listing of claims will replace all prior versions, and listings, of claims in the application:

1. – 8. (Canceled).
9. (New) A die casting machine, comprising:
 - a fixed die having first and second recessed portions;
 - a movable die having third and fourth recessed portions;
 - a sleeve having a first split sleeve connected to the second recessed portion and a second split sleeve connected to the fourth recessed portion;
 - a first movable ejecting pin having a first opening, a second opening, an end, a release agent feed path, and a lubricant feed path, the first opening formed at a portion adjacent to the end and connected to the release agent feed path, the second opening formed at a portion adjacent to the end and connected to the lubricant feed path;
 - a first ejecting pin driver for moving the first ejecting pin; and ,
 - a controller,
- (a) wherein, when the fixed die and the movable die are clamped together:
 - (i) the first recessed portion and the third recessed portion define a cavity,
 - (ii) the second recessed portion and the fourth recessed portion define a first path for guiding a molten metal into the cavity,
 - (iii) the first and second split sleeves define a second path for introducing the molten metal to the cavity through the first path,
 - (iv) the fourth recessed portion defines a hole through which the first ejecting pin is configured to pass;
 - (v) the first opening of the first ejecting pin is directed toward the cavity while the second opening of the first ejecting pin is directed towards the second path; and

(b) wherein, when the fixed die and the movable die are clamped together, the controller:

(i) drives the first ejecting pin driver to move the end of the first ejecting pin into the first path,

(ii) feeds a powder release agent to the release agent feed path, injects the powder release agent through the first opening into the cavity to deposit the powder release agent on the inner surface of the cavity,

(iii) feeds a powder lubricant to the lubricant feed path, injects the powder lubricant through the second opening into the second path to coat the inner circumference of the second path of the sleeve,

(iv) drives the first ejecting pin driver to move a face of the end of the first ejecting pin into alignment with the inner wall of the first path to form a molten metal guide path, and

(v) after completing a casting, drives the first ejecting pin driver to push the first ejecting pin into the casting to separate the movable die from the casting.

10. (New) The die casting machine of claim 9, further comprising:

a second ejecting pin; and

a second ejecting pin driver for moving the second ejecting pin,

wherein the third recessed portion defines a hole through which the second ejecting pin is designed to pass such that, after completing the casting, the second ejecting pin is driven into the casting to separate the fixed die from the casting.

11. (New) The die casting machine of claim 9, further comprising:

an evacuator for reducing the pressure in the cavity when the fixed and movable dies are clamped together,

wherein the control means reduces the pressure, feeds the powder release agent through the first ejecting pin into the cavity and disperses the powder release agent on an inside surface of the cavity by a flow of air generated by the evacuation.

12. (New) The die casting machine of claim 9, wherein:
the first and second ejecting pins are configured to project into a runner in the cavity,
the release agent feed path opens into the cavity side at the first opening of the first ejecting pin, and
the lubricant feed path opens into the sleeve side at the second opening of the second ejecting pin.

13. (New) A die casting machine, comprising:
a pair of dies forming a cavity;
a sleeve having two split parts that are connected to the dies, the sleeve configured to communicate with the cavity formed between the pair of dies and to accommodate feeding of molten metal;
a plunger that fits into the sleeve and injects the molten metal fed to the sleeve toward the cavity;
an electromagnetic pump configured to feed the molten metal inside the sleeve through a melt feed pipe connected to one of the split parts of the sleeve;
an evacuating mechanism configured to evacuate and reduce the pressure inside the cavity when the dies are clamped;
a movable pin having a release agent feeding mechanism configured to feed a powder release agent into the cavity, the powder release agent designed to facilitate release of a casting from the die during evacuation by the evacuating mechanism; and
a lubricant feeding mechanism configured to inject a powder lubricant toward an inner circumference of the sleeve, the powder lubricant designed to reduce friction between the inner circumference of the sleeve and the plunger after the evacuation by the evacuating mechanism; and
a gas evacuating mechanism configured to evacuate gas within the cavity and the sleeve to the outside when pressure inside a closed space formed by inner surfaces of the cavity and the sleeve and a liquid surface of the molten metal inside the melt feed pipe rises above ambient pressure.

14. (New) The die casting machine of claim 13, wherein the gas evacuating mechanism has a check valve provided between a chill-vent provided between the dies and outside of the dies.

15. (New) The die casting machine of claim 14, wherein the gas evacuating mechanism comprises a check valve provided in an evacuation path connecting between the evacuating mechanism and the cavity and the outside of the dies.